

Date: Thursday, 2/9/2006 1:36:13 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT STEP ASSEMBLY LOW SKID RH
Job Number	: 25753		
Estimate Number	: 11117		
P.O. Number	: N/A	Part Number	: D350591216
This Issue	: 2/9/2006 S.O. No. : N/A	Drawing Number	: D3168 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 25092	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 2/20/2006 Qty: 4 Um: Each
Checked & Approved By	: RA 06.02.10		
Comment	: Est Rev: A 02.10.17 New issue KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-216 CHG001

KS 06-02-23

2.0	D2622120C	Extrusion
-----	-----------	-----------



Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

.5 D2622-120 Extrusion 324092

S.L. 06-02-15 = 4

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168

H.L. 06-02-15 4

2-Drill extrusion as per Dwg D3168 using Jig DT8680 for rivets.(Use only 1st 6holes)

H.E. 06-02-15 4

3-Deburr

H.C. 06-02-15 4

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

J. 06-02-17 4

5.0	D30671	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:36:13 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY LOW SKID RH

Job Number: 25753

Part Number: D350591216

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3067-1 End Plate *B24566*

L.E. 06.02.15

4

6.0

D31691

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3169-1

Support

B22569

L.E. 06.02.15

4

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

L.E. 06.02.16

4

2-Weld Support using Jig DT8780, weld Fwd End Plate as per QSI 004 & Dwg D3168

L.E. 06.02.16

4

A/R Aluminum Rod *M18838 & M18839*

3-Grind End Plate flush

L.E. 06.02.16

4

8.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 9

J. DeW

PD 06.02.20

4

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06/02/22

4

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06 02 21

11.0

D30771

Step Leg



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3077-1

Step Leg Assy

B23578

L.E. 06.02.22

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Thursday, 2/9/2006 1:36:13 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY LOW SKID RH

Job Number: 25753

Part Number: D350591216

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D31701

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3170-1

Spacer

323578

SE 06.02.22

4

13.0

MS20600AD4W4

Rivets



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS20600AD4W4

Rivet

M18359

SE 06.02.22

4

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3168

SE 06.02.22

4

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 06.02.22

16.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate

B24097

SE 06.02.22

4

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3168

A/R Aluminum Rod M18838

SE 06.02.22

SE 06.02.22

SE 06.02.22

4

4

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:36:13 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY LOW SKID RH

Job Number: 25753

Part Number: D350591216

Job Number:



Seq. #: Machine Or Operation: Description :

4-Grind End Plate flush

FF 06.02.23 (4)

18.0

QC5/9

WELD INSPECTION



Comment: Inspect work & Weld to Current - Check dimension 108.93" & 3.875" as per Dwg D3272

PD 06.02.24 (4)

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

SAD 06.02.02 (4)

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MM 06.03.07 (4)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3168 and QSI 005 4.4

MM 06.03.07 (4)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

06/03/08 (4)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.3000 f(s)/Unit Total: 1.2000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2182B035 Rubber Cushion B23172

25.0

D2274

Radius Block



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2274 Radius Block B23172 B23372

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:36:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY LOW SKID RH

Job Number: 25753

Part Number: D350591216

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	D2856400	Abrasion Strip
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Comment: Qty.: 0.6000 f(s)/Unit Total : 2.4000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2") Abrasion Strip B 22594 ✓

27.0	D30641	Clamp
------	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3064-1 Clamp B 23406

28.0	D30801	Clamp
------	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3080-1 Clamp B 21677 ✓

29.0	AN335A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt m16114

30.0	AN411A	Bolt
------	--------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-11A Bolt m15057 ✓

31.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer m18359 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/13/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:36:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY LOW SKID RH

Job Number: 25753

Part Number: D350591216

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer m17566 ✓

33.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) m15924

34.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4 Nut (or -4) m15924

1524

C 206103108 (4)

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

u 6/3/8 (4)

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-216

Location:

PPP Rev: A

u 6/3/8 (4)

37.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

u 06/03/09 (4)

Job Completion



u 06.03.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>OP-</i>	DRAWN BY <i>OP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3168	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, LOW SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

Part No.	Description	QTY -041	QTY -042
D3168-041	Step Assembly, Low Short (LH)	X	
D3168-042	Step Assembly, Low Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3067-1	END PLATE	2	2
D3077-1	STEP LEG	2	2
D3169-1	SUPPORT	1	1
D3170-1	SPACER	2	2
MS20600AD4W4	RIVET	12	12

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3169-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25753

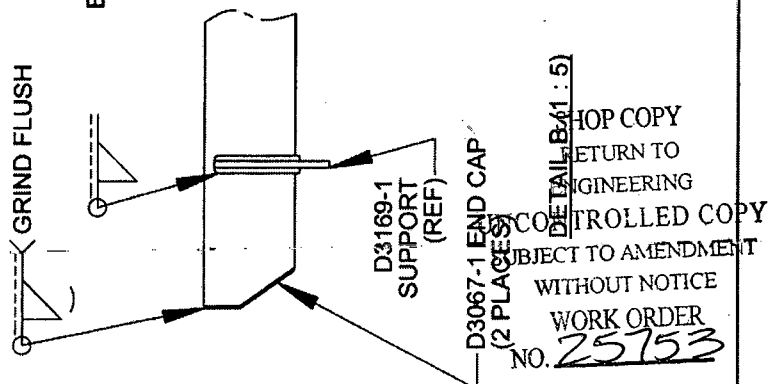
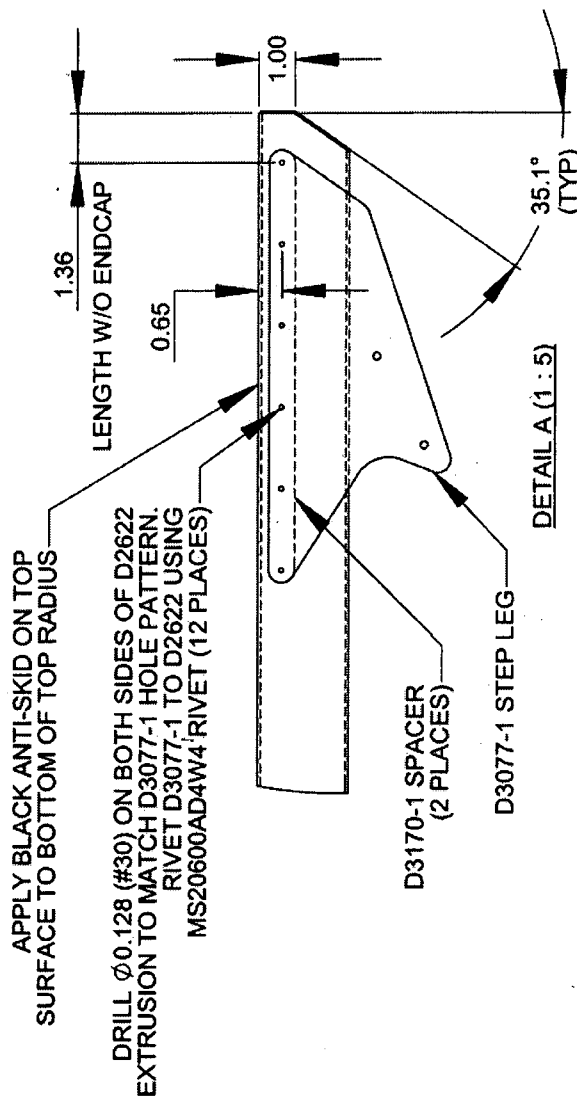
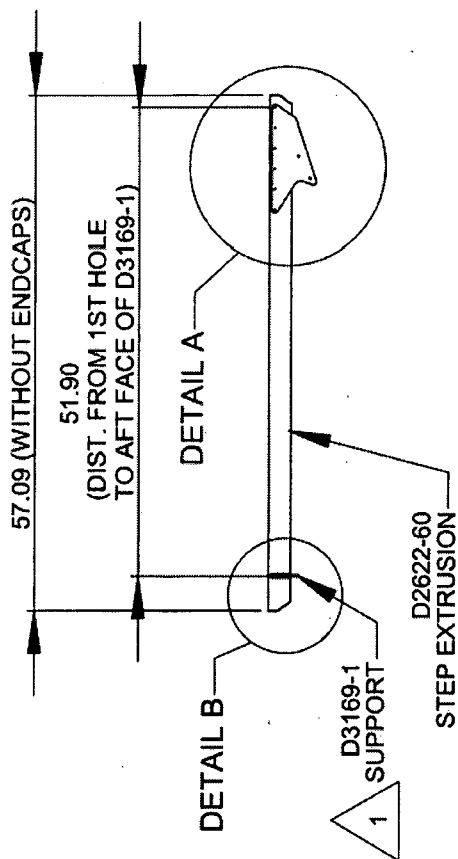
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DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3168	REV. A SHEET 2 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, LOW SHORT SCALE 1:20	

RELEASED
02.09.20



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Date: Friday, 6/23/2006 3:02:21 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D350-591-211/-212/-213/-214/-215/-216
Job Number : 27682
Estimate Number : 10804
P.O. Number : N/A Part Number : Z_CUSTOM
This Issue : 6/23/2006 S.O. No. : N/A Drawing Number : ADD PARTS & PAPERWORK
Prsht Rev. : NC Project Number : N/A
First Issue : 6/23/2006 Type : N/A Drawing Revision : N/A
Previous Run : 00015 Material : N/A
Written By : SEE ASONE USER & DATE Due Date : 6/30/2006 Qty: 24 Um: Each
Checked & Approved By :
Comment :

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DSI9340011 STEP MOD KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)
STEP MOD KIT

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ADD TO KITS IN STOCK

1 X DSI 9340-011 B 27681

STOCK AFFECTED:

D350-591-211 (4 X B18906) ~~OK~~ A

D350-591-212 (0)

D350-591-213 (6 X B27432) 5

D350-591-214 (7 X B26656 / 2 X B25434) OK

D350-591-215 (2 X B26681) 1

D350-591-216 (2 X B25753 / 1 X B26732) OK

Remove: D2182 B035
D3080-1
D3064-1

Add new labels
CITG 002 26667
22m
26667

3.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP & RETURN TO STK

134 67
235 46
132 21
8 X B18750
4 X B23406
4 X B 26667
D3064-1

1683
132.68

26667
22
Aa pcc